

We claim:

1. A mold-in color panel comprising a polymer portion and a non-polymer portion, wherein the polymer portion comprises
 - a first polyolefin comprising a polypropylene material having a haze of less than 20% and a transmittance greater than 80%,; and
 - a second polyolefin selected from the group consisting of a copolymer of ethylene and one or more C₄₋₁₀ α -olefins, a homopolymer of 1-butene, and mixtures thereof; andthe non-polymer portion comprises a pigment, wherein the scratch resistance of the panel is sufficient to give a rating of no more than 2 at 7N force with a 1mm diameter ball when measured according to test method FLTM BN 108-13, the impact resistance of the panel is greater than 2.3 kJ/m² as measured by ISO 180-93, and the transmittance of the panel measured without the pigment is greater than 80%, wherein the haze and transmittance are measured according to ASTM D1003.
2. A panel according to claim 1, wherein the non-polymeric portion further comprises antioxidants or UV absorbers.
3. A panel according to claim 1, wherein the non-polymer portion further comprises slip agents.
4. A panel according to claim 1, wherein the non-polymer portion further comprises polypropylene nucleating agents.
5. A panel according to claim 1, wherein the second polyolefin comprises the product of a metallocene catalyzed polymerization.
6. A panel according to claim 5, wherein the second polyolefin is selected from the group consisting of copolymers of ethylene and butylene, copolymers of ethylene and hexene, and copolymers of ethylene and octene.

7. A panel according to claim 5, wherein the second polyolefin comprises a copolymer of ethylene and octene.
8. A bumper according to claim 1.
9. An interior panel according to claim 1.
10. A panel according to claim 1, wherein the pigment is a special effects pigment.
11. A panel according to claim 1, wherein the pigment is a color pigment.
12. A panel according to claim 1, wherein the first polyolefin comprises a homopolymer of propylene.
13. A panel according to claim 1, wherein the polymer portion consists of the first polyolefin and the second polyolefin.
14. A panel according to claim 1, wherein the weight ratio of the first polyolefin to the second polyolefin is at least 2:1.

15. A composition suitable for producing mold in color panels for automobiles and other uses comprising a polymer portion and a non-polymer portion, wherein the polymer portion comprises:

greater than 40% by weight of a polypropylene material having greater than 3% crystallinity and exhibiting a haze less than 20% or a transmittance greater than 80%; and

less than 20% by weight of a substantially linear copolymer of ethylene and one or more C₄₋₁₀ α -olefins, wherein the copolymer has greater than 3% crystallinity and is produced by polymerization with a metallocene catalyst; and

wherein the non-polymer portion comprises a pigment selected from the group consisting of a color pigment and a special effects pigment.

16. A composition according to claim 15, wherein the polymer portion comprises greater than 70% by weight of the polypropylene material.

17. A composition according to claim 15, wherein the polymer portion comprises greater than 75% by weight of the polypropylene material.

18. A composition according to claim 15, wherein the polypropylene material is produced by metallocene catalysis.

19. A composition according to claim 15, wherein the composition is free of ethylene polypropylene block copolymer.

20. A composition according to claim 15, wherein the composition is free of elastomers.

21. A composition according to claim 15, wherein the polymer portion comprises less than 15% by weight of the copolymer.

22. A composition according to claim 15, wherein the copolymer comprises a copolymer of ethylene and octene.
23. A composition according to claim 15, wherein the copolymer has a melting point greater than 70°C.
24. A composition according to claim 15, wherein the copolymer has a melting point greater than 80°C.
25. A composition according to claim 15, wherein the copolymer has greater than 20% crystallinity.
26. A composition according to claim 15, comprising essentially no inorganic filler.

27. A mold in color panel, having scratch resistance giving a rating of no more than 2 at 7N force with a 1mm diameter ball by test method FLTM BN 108-13 and impact resistance greater than 2.3 kJ/m^2 according to ISO 180-93, the panel comprising:

greater than 75% by weight crystalline polypropylene produced by metallocene catalyzed polymerization of propylene, and having a transmittance of 80% or greater or a haze less than 20%;

less than 15% by weight of a metallocene produced copolymer of ethylene and one or more C_{4-10} α -olefins, the copolymer having a crystallinity greater than 20% by weight and a melting point greater than 80°C ; and a pigment selected from the group consisting of color pigments and special effects pigments,

wherein the haze of the panel without the pigment is 20% or less, with haze and transmittance determined according to ASTM D1003.

28. A panel according to claim 27, further comprising a nucleating agent for the polypropylene.

29. A panel according to claim 27, further comprising a slip agent comprising a fatty acid amide.

30. A panel according to claim 27, wherein the copolymer comprises an ethylene-octene copolymer.

31. A panel according to claim 27, wherein the copolymer comprises an ethylene-butene copolymer.

32. A panel according to claim 27, comprising less than 11% by weight ethylene-hexene copolymer.

33. A panel according to claim 27, comprising less than 11% by weight ethylene-octene copolymer.
34. A panel according to claim 27, essentially free of inorganic filler.
35. A panel according to claim 27, further comprising a nanocomposite filler.

36. A mold-in color panel, comprising
- a polymer composition totaling 100 parts and consisting of 75 or more parts of a polypropylene material having a haze less than 20% and 25 parts or less of a copolymer and ethylene and octene, wherein the polypropylene and the copolymer are produced by metallocene catalyzed polymerization and have greater than 3% crystallinity,
 - a pigment selected from the group consisting of color pigments and special effects pigments; and
 - optional additional components selected from the group of nucleating agents, slip agents, antioxidants, and UV absorbers,
- wherein the panel has scratch resistance to give a rating of no more than 2 according to FLTM BN 108-13 at 7N Force with a 1mm diameter ball, impact resistance greater than 2.3 kJ/m² according to ISO 180-93, and wherein the panel without the pigment has a haze less than 20% measured according to ASTM D1003.
37. A panel according to claim 36, wherein the polymer composition has 80 or more parts polypropylene and 20 or less parts of the copolymer.
38. A panel according to claim 36, wherein the polymer composition has 85 or more parts polypropylene and 15 or less parts of the copolymer.

39. An unpainted polymer panel comprising a pigment and a non-pigment portion, wherein the non-pigment portion comprises
- more than 80% by weight of a polypropylene material with greater than 3% crystallinity; and
 - less than 20% by weight of a polyolefin other than the polypropylene, comprising a metallocene catalyzed homo- or copolymer of C₂₋₁₀ olefins, the polyolefin comprising at least 50 mole % of C₂₋₄ olefins and having a crystallinity greater than 3%;
- wherein the panel has scratch resistance to give a rating of no more than 2 according to FLTM BN 108-13 at 7N Force with a 1mm diameter ball,, impact resistance greater than 2.3 kJ/m² according to ISO 180-93, and wherein the panel without the pigment has a haze less than 20% measured according to ASTM D1003.
40. A panel according to claim 39, wherein the polyolefin has a crystallinity greater than 10%.
41. A panel according to claim 39, wherein the polyolefin has a crystallinity greater than 20%.
42. A panel according to claim 39, wherein the polypropylene material is a product of metallocene catalyzed polymerization of propylene.
43. A panel according to claim 39, wherein the polypropylene material comprises a homopolymer of propylene.
44. A panel according to claim 39, wherein the polypropylene material is a propylene homopolymer.
45. A panel according to claim 39, wherein the panel comprises essentially no elastomers.

46. A panel according to claim 39, wherein the polyolefin comprises a copolymer of ethylene and octene.

47. A panel according to claim 39, wherein the polyolefin comprises a homopolymer of 1-butene.

48. A panel according to claim 39, wherein the polyolefin comprises a copolymer of ethylene and butene.

49. A panel according to claim 39, wherein the polyolefin comprises a copolymer of ethylene and hexene.

50. A panel according to claim 39, wherein the non-pigment portion further comprises a nanocomposite filler.

51. A method for making a colored polymer article, comprising
dispersing a pigment into a polymer composition to form a colored
composition, and
forming the colored composition into the article,
wherein the polymer composition comprises
greater than 40% by weight of a polypropylene material having greater than
3% crystallinity and exhibiting a haze less than 20% or a transmittance
greater than 80%; and
less than 20% by weight of a substantially linear copolymer of ethylene and
one or more C₄₋₁₀ α -olefins, wherein the copolymer has greater than 3%
crystallinity and is produced by polymerization with a metallocene
catalyst.
52. A method according to claim 51, wherein the pigment is provided in the form of a
masterbatch comprising pigment and a polymeric carrier.
53. A method according to claim 52, wherein the polymeric carrier comprises a
polypropylene material.
54. A method according to claim 51, wherein forming comprises injection molding.
55. A method according to claim 51, wherein forming comprises thermoforming
56. A method according to claim 51, wherein forming comprises compression
molding.

57. A method for making a colored polymer article, comprising
dispersing a pigment into a polymer composition to form a colored
composition, and
forming the colored composition into the article,
wherein the polymer composition comprises
more than 80% by weight of a polypropylene material with greater than 3%
crystallinity; and
less than 20% by weight of a polyolefin other than the polypropylene,
comprising a metallocene catalyzed homo- or copolymer of C₂₋₁₀ olefins,
the polyolefin comprising at least 50 mole % of C₂₋₄ olefins and having a
crystallinity greater than 3%.